DART AEROSPACE LTD	Work Order:	24717
Description: Redurn 421	Part Number:	K10008
Dwg:	Qty:	
		Page of

Step	Location	Procedure	Ву	Date	Qty
1	DC	issue Traveler		Date	Giy
				,	
1	QC4-5	Inspect Kit forcompletness and chamage	1	570.27	1
2	PK	re-package as per PPP K10008 Rev. E,	PCL.	5111/07	1
		And Place back into stock with origin 1			
		batch number.			
4	AC	cost:	SUE.	05-11-24	/
5	Dc/QC21	Close w/o:	0	05/11/00	1
	·	ĕ ®			
		•			
	·			*	
	<u>-</u>				
			1 1	I	- 1

Rev	Date	Change	Revised By	Approved
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Li				

: 5/15

Skit

DART AEROSPACE LTD		
PART MEROST ACE LID	Work Order:	22493B
Description: Bearpaw Kit (19" x 24")		
Description: Bearpaw Kit (19 x 24")	Part Number:	K10008
Dwg : D2432 Rev. F3		
Ref: K10008 Rev. E; DSK086-5 Rev. A	Qty:	1/ 28 Kits
Step Location Procedure		Page 1 of 1

	C4				Page 1 of	1
-	Step		Procedure	By	Date	104
	1	DC	Issue Traveler	IA	Date	Qty
			Note: (1) K10008 Kit consists of Qty (2) D2432F	HAI	10000	سرد ا،
-	2	-	Dwg not required	JY XI	05.02.2	1195
	2	DC	Photocopy bluefile: K10008	+-		+
			D206-559-013			
			D350-578-011 D315-670-011 WL 13	•		
						\perp
			D427-659-011	DH	05.03.17	114
			and create labels per PPP K10008 CHG006		,	'
-	3	GA	(Bag Bluefiles separately)			
	Ü		Cut 2 blanks per (1) K10008 Kit			
			Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5			
			D51/000-3			
		1	Material: Black UHMW 1" (MUHMWB10) Batch: A ICGO I	Λ	<i>e</i> .	,,
-	4	MV	Dulch, Piling II.	We	05/03/018	BL.
-			Inspect material for defects or damage prior to machining	m	Jak.	611
	5	MV	Machine as per Folio D2432 and Dwg D2432	1.2	0503/04	246
-	6	QC2	Identify as D2432F	Til	a ~/03/11	14
			Inspect parts as they come off the CNC machine	3/1	11/20/5/1	
	7	MV	Deburr	310	05/03/11	14
	8	QC8 & 5	Second inspection	12	05/03/11	14
	9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material	K	05/03/11	14
1			from step 3)			
			Oty Part Number Descripti			
İ		\	D2182B050 Rubber Cushion 32c434/0	199	40× 321	105
		*			19 000	70>
	-	\(12) D2274 Radius Block <u>B30427/B3</u> D2432F 24" Bearpaw <u>B32493</u>	158	>KR 318	46)
		×.	D2438 Clamp \$ 2.100	-		
	1	N	12 D2529 Washer 23.667A			
		X	6) D2732-050 Rubber Cushion 5000433			
			AN4-15A Bolt M 15321			
		7	12 AN4-17A Bolt (0.14) 50/			
		Œ.	AN900JD416 Washer m15993			İ
		¥	12 MS21042L4 Nut (or -4) M15020		1	1
			raperwork package from Step 2			
10)	QC4	IIISPECIAL TOP 100% Completeness on the M/O	.6	5 103/16	11
11		PK	Identify and nack for chipping as a DDD (Vocana	<u>'X b</u>	5/03/17	
12	$-\!\!+\!\!\!-$	AC	Identify and pack for shipping as per PPP K10008 Rev. E	16	5/03/17 1	,
13	; T	DC (Close W/O 274,25	4-	15.50.7	11
	\bot		nspect Level 21		× 02 . 1	11
				IMI	N.03.17	11

Rev	Date	Change	17	
F	02.05.22	Chg 005 (MPP 2245)	Revised By	Approved
G		<u> </u>	NG	
Н		Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
		Added D427-659 to Step 2	KJ	
		Reformat; Incorporated D2432F	KJ/RF	
L	04.02.17	Blank size changed on Step 3	KJ/JLM	-#-

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1.3/15

SPLIT

DART AEROSPACE LTD	Work Order:	22493
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg : D2432 Rev. F3	Qtv:	15 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	111		- City
		Note: (1) K10008 Kit consists of Qty (2) D2432F	DA	05.02.21	15
2	DC	Dwg not required	10	,	13
		Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 (Bag Bluefiles separately)	24	05,03.09	1
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: ►1 156 → 1	me	nsloslau	1
4	MV	Inspect material for defects or damage prior to machining	me	20/22/016	20
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	m	2000104	1
6	QC2	Inspect parts as they come off the CNC machine	Pan D	05/03/09	1
7	MV	Deburr	and	05/03/09	'
8	QC8 & 5	Second inspection	FI	05.03.09	-
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Oty Part Number Description Batch 6 D2182B050 Rubber Cushion B20434 12 D2274 Radius Block B20927 2 D2432F 24" Bearpaw B222493 6 D2438 Clamp B21187 12 D2529 Washer B21587A 6 D2732-050 Rubber Cushion B20433 12 AN4-15A Bolt YM8525/MIYUS/MI454Y 12 AN4-17A Bolt M12612 24 AN960JD416 Washer M15020 12 MS21042L4 Nut (or -4) M15020 1 Paperwork package from Step 2			
10	QC4	Inspect Kit for 100% Completeness on the W/O		5/03/09	
11	PK	Identify and pack for shipping as per PPP K10008 Rev E	3B	25/03/09	4
12	AC	Cost / part ZZ Y, Zo	1	05/03/10	
13	DC	Close W/O ZZ / , Zo Inspect Level 21	-1 /	05.03.10	/

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
Н	02.08.15		KJ	
1	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	-#-

Pyl 05-03-10

1.15/15

Slit

DART AEROSPACE LTD	Work Order:	22493岁
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	3 % Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	H)	05.02.21	
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 (Bag Bluefiles separately)	DH	05.04,05	3
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15426	me"	05/03/04	bld
4	MV	Inspect material for defects or damage prior to machining	me	05/03/04	64
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	Til	05/03/11	14
6	QC2	Inspect parts as they come off the CNC machine	me	05/03/11	14
7	MV	Deburr	Int	05/03/11	14
8	QC8 & 5	Second inspection	te	05/03/11	14
9	KP		325	140/B218 5/B218 1505	46
10	QC4	Inspect Kit for 100% Completeness on the W/O		, , ,	<u> </u>
11	PK	Identify and pack for shipping as per PPP K10008	J - 1	05/03/28	3
12	AC		ا	02102118	3
13	DC	Cost / part / 6 <i>F, 15</i> Close W/O <i>Z Z F, Z</i> / Inspect Level 21	#	05.04.05	3

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
Н	02.08.15	Added D427-659 to Step 2	KJ	
ı	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	-#

BR 05-03-36

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